

Work Order ID 62391

Wednesday, September 29, 2010 10:23:44 A

Page 1

Item ID: D2521

Accept

Setup Start

Revision ID:

Stop

Item Name: Bearpaw 205

Start Date: 9/29/2010 Start Qty: 12.00

Cust Item ID:

Required Date: 10/7/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2521

Rev J

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2521 blank file

B10-10-4

12

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D2521 Identify as D2521
3-Deburr

SL 10/10/13

12

8

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 10/10/13

12

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




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Wednesday, September 29, 2010 10:23:44 A

Page 2

Item ID:	D2521	Accept		Setup	Start	
Revision ID:						
Item Name:	Bearpaw 205				Stop	
Start Date:	9/29/2010	Start Qty:	12.00	Cust Item ID:		
Required Date:	10/7/2010	Req'd Qty:	12.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC8- Inspect parts - second check Memo <i>10/10/13</i>	0.00 0.00				12	6		
160  Packaging Packaging	Identify as per dwg & Stock Location: Memo	0.00 0.00		<i>PP 62389</i>			<i>10/10/18</i>		<i>(12)</i>
170  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						<i>10/10/19</i>	<i>ME 10-10-18</i>

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Picklist Print

Wednesday, September 29, 2010 10:23:48 AM

Page 1

Work Order ID: 62391



Parent Item: D2521



Parent Item Name: Bearpaw 205


Start Date: 9/29/2010

Required Date: 10/7/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-10-01 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10  UHMW 1" Black		Purchased	No				sf	295.3533	7	88.42105			



10-10-4

Location

Loc Qty

Loc Code

MAT

295.3533

113903

79.7473

114624

8.8

115325

206.806

115328

12

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DART AEROSPACE LTD		Work Order:	42821
Description: Bearpaw		Part Number:	D2521
Inspection Dwg: D2521 Rev: J		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	.260	✓		vern JL-3	
B	0.90	0.96	.933	✓		"	
C	0.27	0.330	.316	✓		"	
D	0.470	0.530	.500	✓		"	
E	21.740	21.760	21.750	✓		m-tape	
F	0.72	0.780	.750	✓		vern JL-3	
G	0.35	0.410	.382	✓		"	
H	11.490	11.570	11.490	✓		vern CNC02	
I	3.41	3.47	3.430	✓		vern JL-3	
J	11.790	11.810	11.800	✓		vern CNC02	
K	9.47	9.53	9.5	✓		"	
L	7.190	7.210	7.200	✓		"	
M	6.910	6.970	6.930	✓		"	
N	44.47	44.530	44.50	✓		m-tape	
O	6.590	6.650	6.620	✓		vern CNC02	
P	0.940	0.980	.958	✓		vern JL-3	
Q	18.97	19.03	19.00	✓		m-tape	
R	0.350	0.410	.382	✓		vern JL-3	
S	0.740	0.780	.758	✓		"	
T	0.240	0.280	.251	✓		"	
U	0.370	0.410	.380	✓		"	
V	0.740	0.780	.745	✓		"	
W	0.740	0.780	.755	✓		"	

Measured by:	JL	Audited by:	SA	Prototype Approval:	N/A
Date:	16/10/13	Date:	10/10/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM	

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NOTE: Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2521	REV. J SHEET 1 OF 3
DATE 06.07.28		TITLE 205 BEARPAW	SCALE NTS
A	95.11.28	NEW ISSUE	
B	96.01.11	SHOW BENDING MOVE HOLES	
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING	
D	96.05.14	ADJUSTED BEAR PAW THICKNESS	
E	96.12.18	43.500 WAS 46.750	
F	97.05.07	ADDED REAR POCKET, MOVED HOLES	
G	98.08.06	ADD C'BORE AND CHAMFER EDGES	
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.	
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES	
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. U2391
B010-9-29

RELEASED
06 08.23 #

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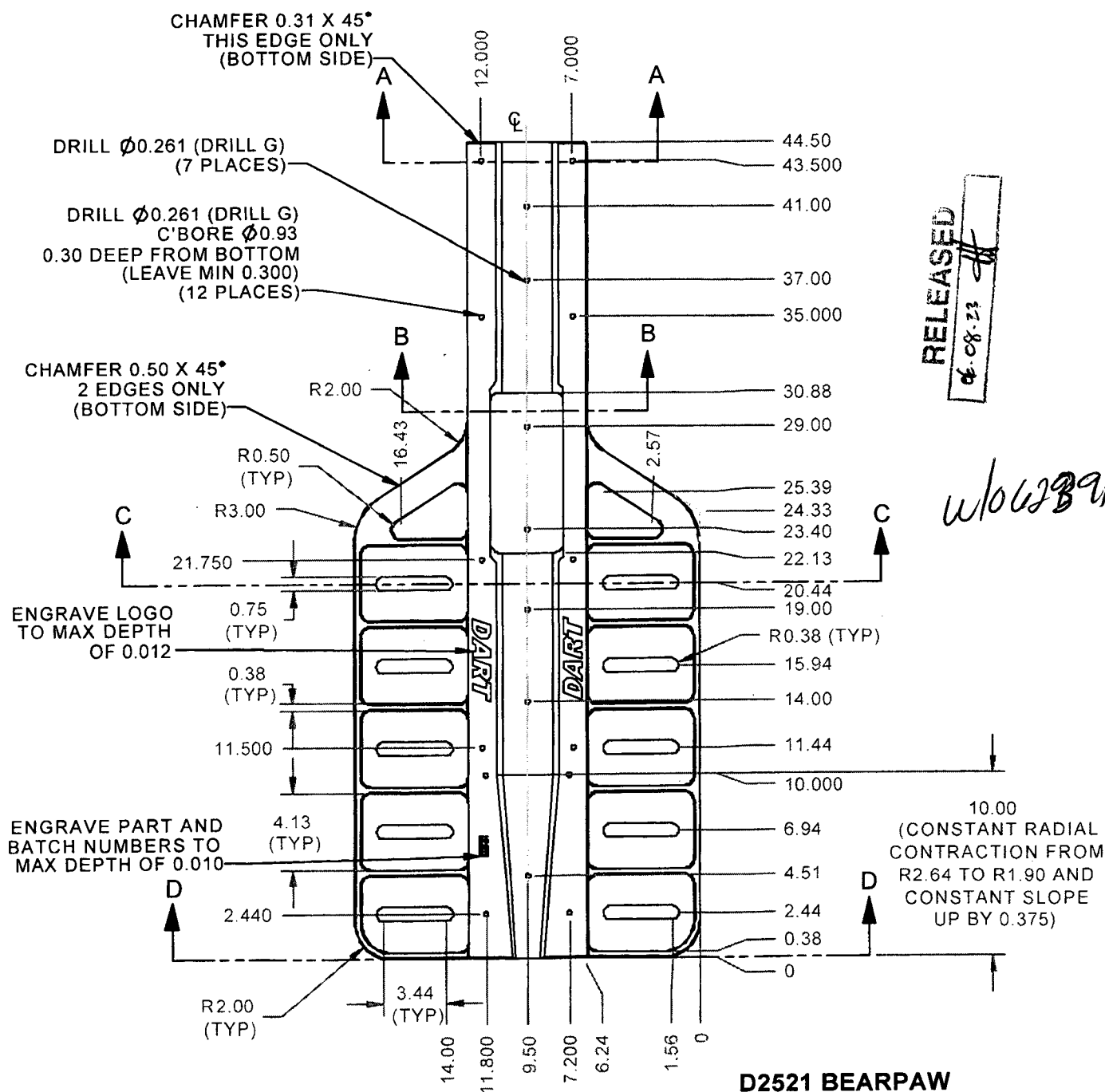
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

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CHECKED CP	APPROVED [Signature]	DRAWING NO. D2521	REV. J
DATE 06.07.28	TITLE 205 BEARPAW	SHEET 2 OF 3	
		SCALE 1:8	

**NOTES:**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
- 6) PART IS SYMMETRIC ABOUT C

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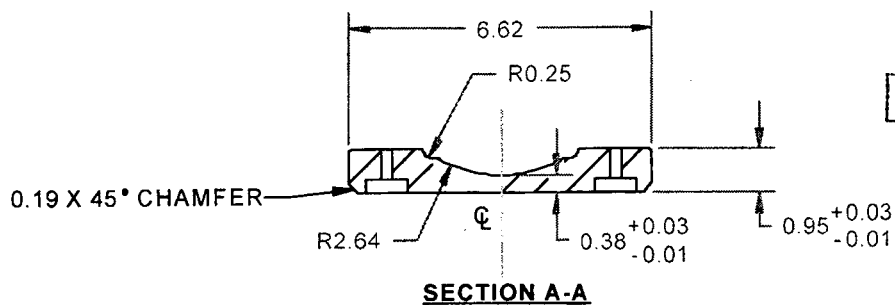
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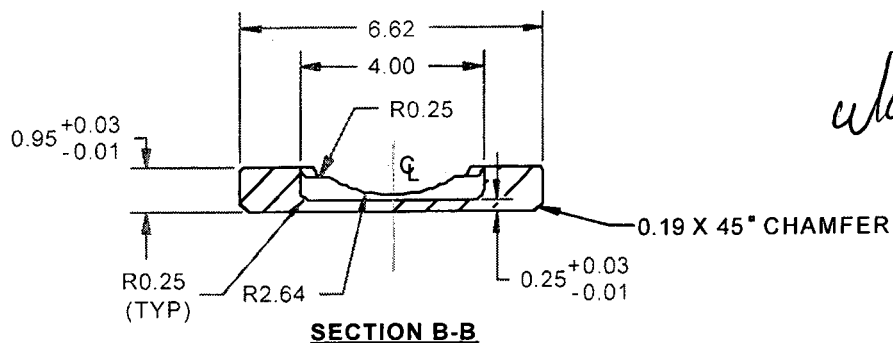
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DART

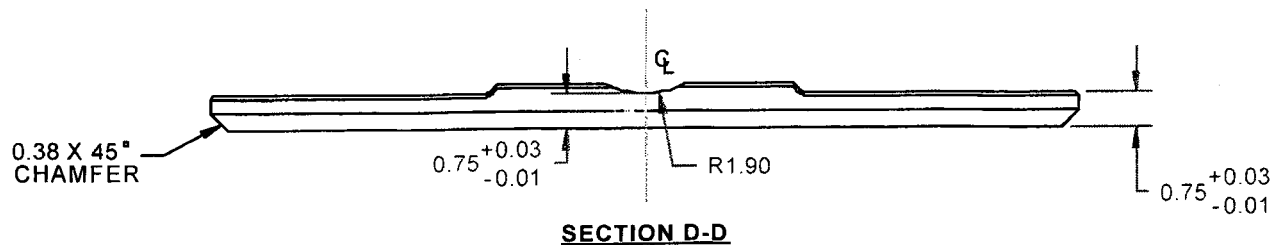
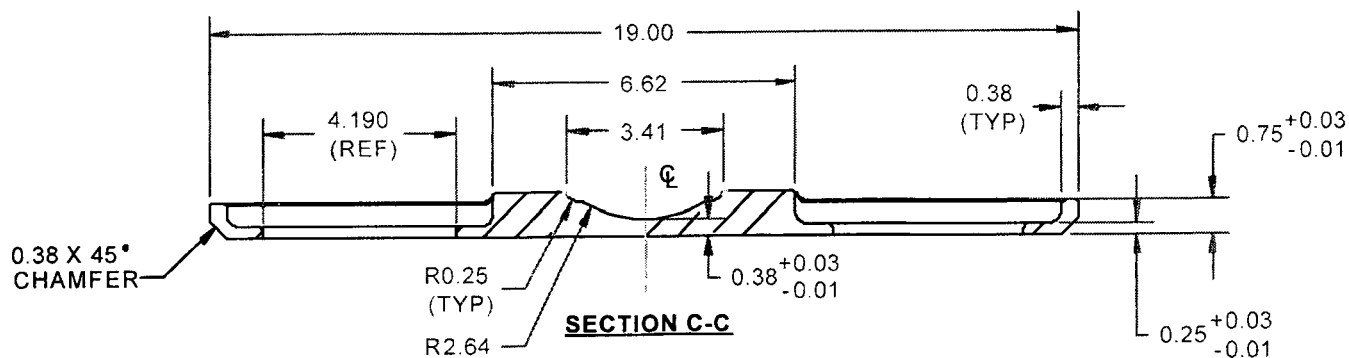
DESIGN #	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2521	REV. J SHEET 3 OF 3
DATE 06.07.28	TITLE 205 BEARPAW		SCALE 1:4

**RELEASED**

06.08.23



w/o 62891



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